

Date: Wednesday, 11/21/2007 1:16:22 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : T-BEAM EXTRUSION
Job Number : 35952	
Estimate Number : 10043	
P.O. Number : <i>N/A</i>	Part Number : D6201
This Issue : 11/21/2007 S.O. No. : <i>N/A</i>	Drawing Number : D6201 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LANDING GEAR	Drawing Revision : A
Previous Run : 29367	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 12/5/2007
Checked & Approved By : <i>[Signature]</i>	Qty: <i>20</i> Um: Each
Comment : Est. A: 01.05.15 New Issue EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *5116**020711122**(20)*

a) Description: T-beam extrusion

b) 4.00" x 4.00" x 0.375"

c) Minimum Ultimate Tensile Strength = 38ksi

d) Minimum Yield Tensile strength = 35ksi

e) Material: 6061-T6/T6511 (QQ-A-200/8)

f) Material certification required

2.0

D6201P

T Extrusion 4X4X3/8



Comment: Qty.: 1.0000 f(s)/Unit Total : 12.0000 f(s)

T Extrusion 4X4X3/8

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

*07/11/28**(20)*

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6104

*S 07/11/28**(x20) 07/11/28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/14/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 1:16:22 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: T-BEAM EXTRUSION

Job Number: 35952

Part Number: D6201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

J.F. 07/11/28 20 Feet

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Don 11/30

Job Completion



U 07-11-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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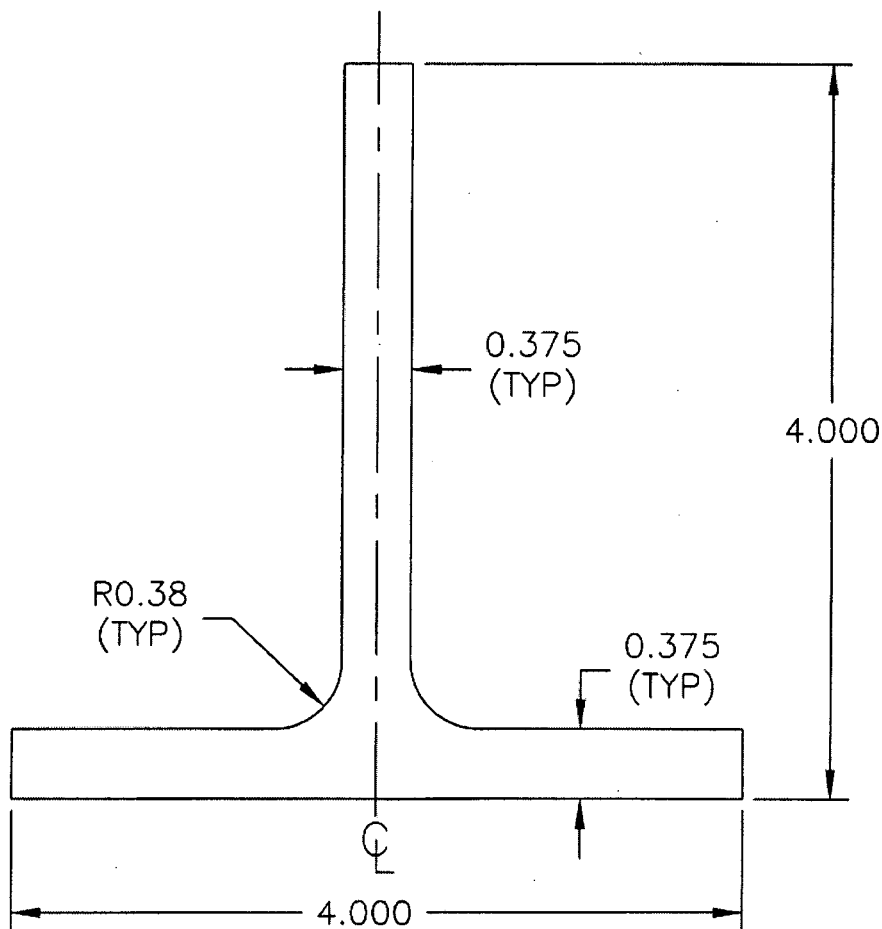
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6201	REV. A SHEET 1 OF 1
DATE 01.04.10		TITLE T-BEAM EXTRUSION	SCALE 1:1
A	01.04.10	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
01.04.23 *JS*



D6201-XXX T-BEAM EXTRUSION
WHERE XXX IS LENGTH IN INCHES

EG.
D6201-027 IS 27 INCHES LONG

PURCHASE MATERIAL: ALUMINUM "T"-EXTRUSION ROUND FILLET
4.000" x 4.000" x 0.375"
6061-T6/T6511 (QQ-A-200/8)
MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi
MINIMUM YIELD TENSILE STRENGTH = 35 ksi

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35952

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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sapa:

Sapa Industrial Extrusions
53 POTTSVILLE STREET
CRESSONA, PA
17928-0187

Sapa Extrusions Inc., Subsidiary of Sapa AB

Invoice To Customer

Certified Inspection Report

Sales Order Number
4865193

Customer P/O
N20286-1

Cert Number SAPA1284658	Page 1 of 2
Cert Creation Date 21-SEP-07	Cert Print Date 21-SEP-07


Quantity Shipped	Date Shipped	Item Description
1648 LB	21-SEP-07	Extruded Canadian Tee
B/L	Item No.	4 W x 4 H x 0.375 TK x RAD. 375 ICR
1380747	G03378655	SECT 760002
Delivery ID	Item No. Rev	240 IN LN
2522752	--	6061 / T6
Customer Part No		FIN M-MILL
V872002		W/F 3.433 F 5 CS 5
		Marking CONTINUOUS;
		ASTMB221 REV 06
		ASMESB221 REV
		AMS-QQ-A-200/8 REV
		ASTMB308 REV 02
		ASMESB308 REV
		AMS-QQ-A-200/16 REV

Applicable Specifications, Revisions and Exceptions

COMPOSITION NOTE: The values for 'Others Each' and 'Others Total' have met the limits as shown on this certified inspection report. Remainder is Aluminum.

Legal Statement

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and that samples representative of the material met the composition and had the mechanical properties shown on the face of this certification. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our product. This certification is not to be reproduced in partial form without prior written approval of our Quality Assurance Dept.

Signature And Title


Dave A. Lukasak
Tech/Quality Manager

21-SEP-07

Quantities per Lot/Packages

Package Number	Lot Number	Quantity	UOM	Weight	
				Gross	Net
G12-PKG684548	8504125	12	PCS	832	824
G12-PKG684549	8504125	12	PCS	832	824

#commande 874346

#client 24532-5

#item 2

Composition Limits

Alloy	Si		Fe		Cu		Mn		Mg		Cr	
	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
6061	0.40	0.8	---	0.7	0.15	0.40	---	0.15	0.8	1.2	0.04	0.35

Alloy	Zn		Ti		Bi		Pb		Others Each		Others Total	
	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max	Min	Max
6061	---	0.25	---	0.15	---	0.05	---	0.05	---	0.05	---	0.15

sapa:

Sapa Industrial Extrusions
53 POTTSVILLE STREET
CRESSONA, PA
17929-0187

Certified Inspection Report

Sales Order Number

4865193

Line No. 1

Customer P/O

N20286-1

Cert Number

SAPA1284658

Page

2 of 2

Cert Creation Date

21-SEP-07

Cert Print Date

21-SEP-07

Composition Results

Heat / Cast	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Bi
9017314	0.7	0.22	0.27	0.02	0.9	0.05	0.02	0.02	--

Heat / Cast	Pb	Others Each	Others Total
9017314	--	--	--

Mechanical Property Test Limits

Test Type			UTS - L		TYS - L		EL 4D-Long	
UOM			KSI		KSI		PCT	
# of Tests			--		--		--	
Test Temper	Lot Number	# of Tests	Min	Max	Min	Max	Min	Max
T6	8504125	1	44.2	44.2	41.0	41.0	18.2	18.2

Cert Notes

Products manufactured with a T6511 temper also meet T6 temper requirements.
Yield strength has been determined by the 0.2% offset method
Made in USA